

WHAT IS CLAIMED IS:

1. A charging roller for a contact charging assembly, comprising a conductive substrate, an elastic layer which covers the periphery of the
5 conductive substrate, and a seamless tube externally so fitted as to cover the periphery of the elastic layer,

wherein said seamless tube constitutes a surface layer of the charging roller, and

10 wherein said charging roller has a surface of 3.0 μm or less in ten-point average roughness Rz jis 94, and 0.10 mm or less in roughness curve average length RSm.

15 2. The charging roller according to claim 1, wherein said seamless tube comprises a high-impact polystyrene HIPS.

3. The charging roller according to claim 1,
20 wherein said seamless tube comprises:
(A) a thermoplastic styrene elastomer, and
(B) a high-impact polystyrene HIPS;
and a proportion of the component (A) to the component (A) is $(A)/(B) = 80/20$ to $40/60$ in weight ratio.

25 4. The charging roller according to claim 1,
wherein said seamless tube comprises a multi-layer

structure having a plurality of layers.

5. A process cartridge comprising an
electrophotographic photosensitive member and the
charging roller according to claim 1 which are
integrally supported together, and being detachably
mountable on a main body of an electrophotographic
apparatus.

10 6. An electrophotographic apparatus comprising an
electrophotographic photosensitive member and the
charging roller according to claim 1.